

Work Order ID 82931

Tuesday, April 10, 2012 4:00:50 PM

82931

Page 1

Item ID: D3916-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Rib Assembly

Start Date: 4/10/2012 Start Qty: ~~5.00~~ ^{6.00}

5

Cust Item ID:

Required Date: 4/24/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: P

Date: 12-04-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3916	A								

100

0.00

100

Large Fab

Large Fab

Memo

0.00

- 1- Cut tube 50"
- 2- Bend tube with manuel pipe bender as per DT9567
- *** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***
- 3- Trim access tube material to finish size as per dwg D3916
- 4- Drill and chamfer holes as per dwg D3916-1 using DT9605

6 SAJ
12-04-09

105

QC6- Inspect dimensions to drawing

0.00

105

QC

Quality Control

Memo

0.00

12-05-09 6x

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

82931

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 4/10/2012 **Start Qty:** 5.00

5

Customer:

Required Date: 4/24/2012 **Req'd Qty:** 5.00

5

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

Weld per dwg A/R S.S. rod Batch: M11816

0.00

107

Memo

0.00

Large Fab

1- weld bushing as per dwg D3916
2- grind welds flush

Large Fab

QC5- Inspect part completeness to step on W/O

0.00

110

Memo

0.00

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

120

Memo

0.00

QC

Quality Control

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Tuesday, April 10, 2012 4:00:50 PM

82931

Item ID: D3916-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Rib Assembly

Stop *NS2*

Start Date: 4/10/2012 **Start Qty:** 5.00

5

Cust Item ID:

Required Date: 4/24/2012 **Req'd Qty:** 5.00

5

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #Plan
Code

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

130

Identify as per dwg & Stock Location:

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

6x

12/5/14
ME
12-05-14

W/O:		WORK ORDER CHANGES						
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Picklist Print

Tuesday, April 10, 2012 4:00:54 PM

Page 1

Work Order ID: 82931

82931

Parent Item: D3916-041

D3916-041

Parent Item Name: Rib Assembly

Start Date: 4/10/2012

Required Date: 4/24/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1

Manufactured

No

100

Each

192.0000

7

35

D3759-1

Bushing

**

12-05-14

Location

Loc Qty

Loc Code

WA

191

79213

191

WA005

1

66489

1

M304TS0.750W.049

Purchased

No

100

f

519.6045

4.166

21.92632

M304TS0 750W 049

304 SQ Tube .75x.75x.049W

**

SAD 12-05-09

Location

Loc Qty

Loc Code

MAT018

248.3105959

117775

93.6739

118472

47.1990839

118880

0.2736

119147

76.4906

119643

17.1154

120494

13.5580119

MAT034

248.367327

117337

1.8507

121087

246.516627

WA035

22.92654

118184

22.92654

2121439

26.3116

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

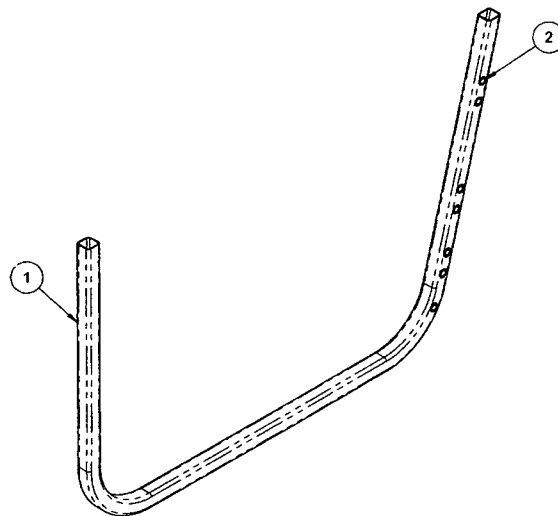
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

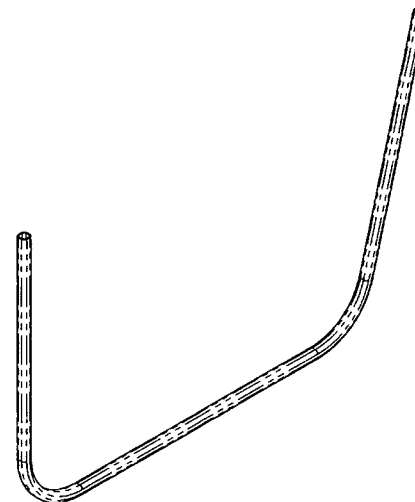
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ITEM	QTY	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82931

12-04-0

OK 10.12.21
UNDER REVIEW
ADDITION OF HOLE + BUSHING
on D3916-041-1 RIBS.

RELEASED
2010-03-12
JMP

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT PREVIOUS PERMISSION FROM DART AEROSPACE LTD.</small>	

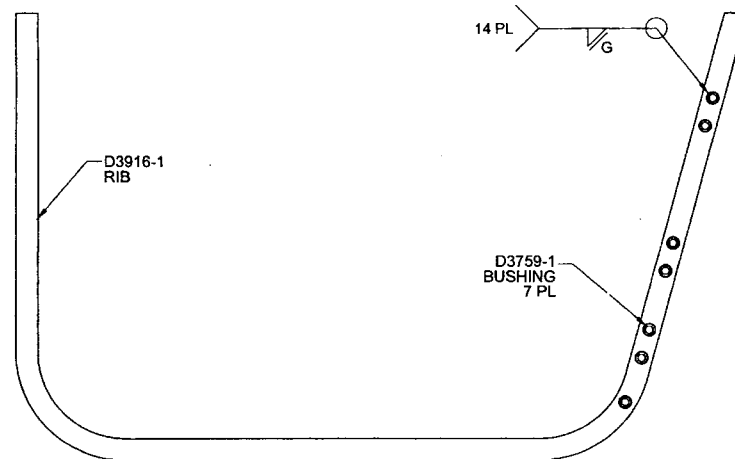
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D3916-041 RIB ASSY

82931

RELEASED
2010-03-12
ANT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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2010-03-12

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